

Ship 08/03

Work Order ID 56581



March 1, 2010 2:46:15 PM

Item ID: D3713-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Lid Assembly

Start Date: 3/01/10 Start Qty: 1.00



Cust Item ID:

Required Date: 3/08/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

W

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3713	Rev B
-------	-------

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- drill holes in both D3715-1 as per dwg D3715 12- deburr 13- assemble as per dwg D3713 and weld as per QS1004

① *pc 10-03-03*

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- cut mesh as per dwg D3743 12- weld mesh as per dwg D3713

SAD 10-03-02

②

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/08/03

③

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56581

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Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Quality Control

Memo

0.00

①

PD 1003-03

140

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Powder Coating

Memo

0.00

START TIME: 11:00AM OVEN TEMPERATURE:

11:30AM FINISH TIME: 320°F

=> M 105642 => Jd 10/03/04

(X1)

Ø

150

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

ml

10 03 04 ①

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



HandFinish

Hand Finishing

HandFinishing

Memo

1-Apply Wing Walk on mesh as per Dwg D3713 and QSI 005 4.4 2-apply armor shield over label on lid only

Label B# 55439
Armor shield B# 105320

0.00

D37471

BR 10-3-4 ①

ML 10 03 18 ①

170



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

Pa 10/3/19 ①

180



Packaging

Packaging

Identify as per dwg & Stock Location:

Memo

0.00

0.00

PP 57057

10-3-19 SL

Work Order ID 56581

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Cust Item ID:

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Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/24 JF

C210/3119

Picklist Print

March 1, 2010 2:46:13 PM

Page 1 / 3

Work Order ID: 56581



Parent Item: D3713-042



Parent Item Name: Lid Assembly

Start Date: 3/01/10

Required Date: 3/08/10

Comments: IPP Rev:A new issue 08-01-30 DD verified by:EC
IPP Rev:B change to revB ecn 1145 08-03-19 DD verified by:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2327-1

Manufactured

No

100

Each

33.0000

2.0000



Spacer Bushing

Cpl 10-03-02

Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

ST

33

52832

13

54658

20

12 Cpl

D2329

Manufactured

No

110

Each

12.0000

1.0000



Label Plate

Cpl 10-03-02

Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

ST

12

35686

2

40488

10

1 Cpl

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Start Date: 3/01/10

Required Date: 3/08/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2581



Mounting Bracket



Pl 10-03-02

Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

ST 5

46086 2

48428 1

51120 2

Main Warehouse

WA 42

50872 1

51745 2

55918 39

D3749-1



Hinge Half

Manufactured No

100 Each

12.0000 3.0000



1 2 Pl

Pl 10-03-02

Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

ST 12

38826 12

1 3 Pl

March 1, 2010 2:46:13 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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IPP Rev:B change to revB ecn 1145 08-03-19 DD verified by:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304EX0.75-16F		Purchased	No			100	sf	873.8291	17.8947			



Expanded Metal Flat SS



SAD

10-03-02

Warehouse Loc Qty Loc Code
Location

Main Warehouse

MAT

873.8291065

111956

0.000017

112147

9.4736E-06

112949

19.84438

113205

0.0093

113497

0.1449

113555

667.7873

113904

186.0432

M304TS0.750W.065

Purchased

No

100

f

221.2637

32.6547



304 SQ Tube .75x.75x.065W



17.8947

SAD

10-03-02

Warehouse Loc Qty Loc Code
Location

Main Warehouse

MAT

221.2636712

113082

0.00419

113245

0.00038421

113683

0.30855

113836

5.161147

113956

215.7894

Main Warehouse

WA

0.0000047

112398

0.0000047

11.5

21.1548

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

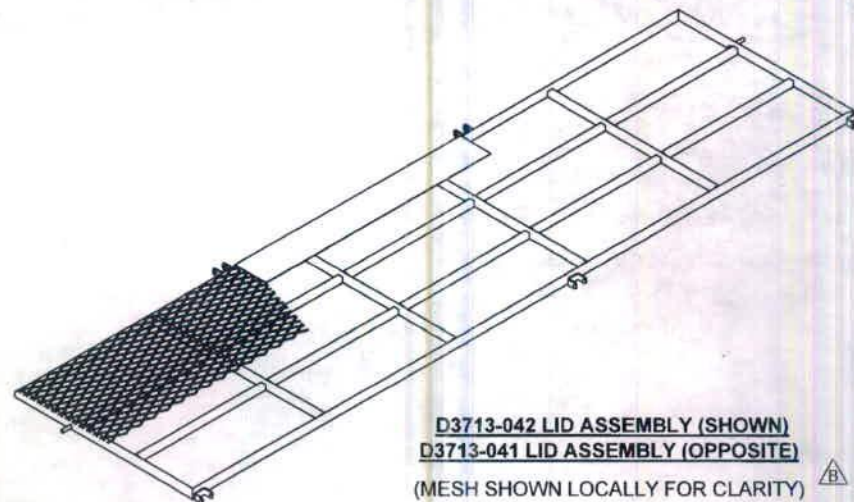
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

WLO 56581

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3713-041	LID ASSEMBLY
	X	D3713-042	LID ASSEMBLY
2	2	D2327-1	SPACER
1	1	D2329	LABEL PLATE
2	2	D2581	MOUNTING BRACKET
2	2	D3714-1	RIB
2	2	D3715-1	RIB
10	10	D3716-1	RIB
4	4	D3732-1	RIB
1	1	D3743-1	MESH
3	3	D3749-1	HINGE HALF

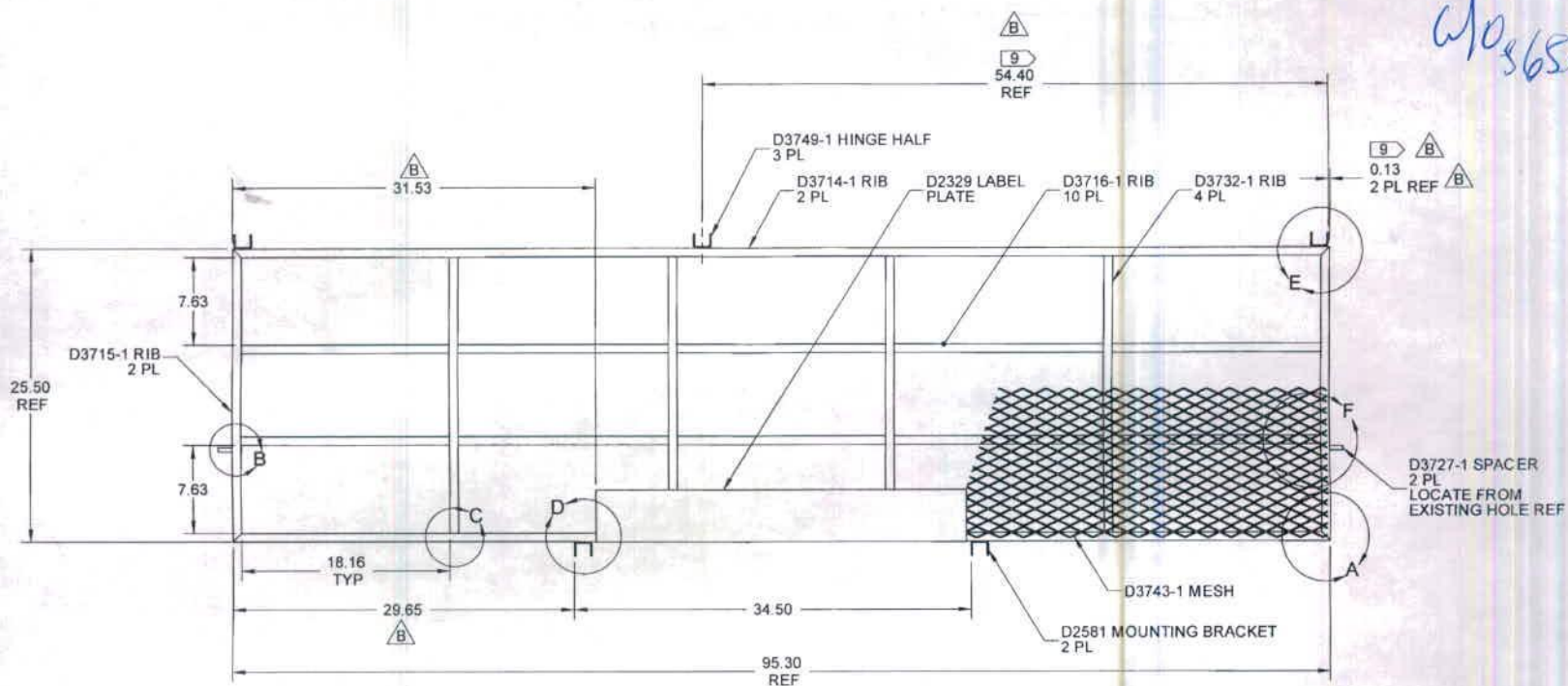


D3713-042 LID ASSEMBLY (SHOWN)
D3713-041 LID ASSEMBLY (OPPOSITE)
 (MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

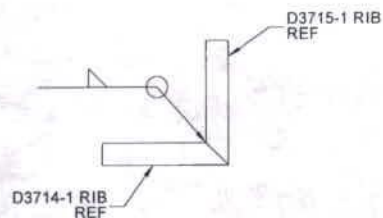
- 1) MATERIAL: NONE
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
 APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004
- 9) CENTER D3749-1 HINGE HALF ON D3748-1 HINGE HALF ON D3712-041/042 BASKET BASE ASSEMBLY

B	SHEET 1 -042 WAS -041: ADDED CORRECT -041 ASSEMBLY. NOTE 9 ADDED. ZONE C2 LID ASSEMBLY WAS D3713-041. WEIGHT WAS 36 lbs. SHEET 2 ZONE B5 LID ASSEMBLY WAS D3713-041. ZONE D6 31.53 DIM WAS 31.64. ZONE D3 54.40 DIM NOW REF. ZONE D2 0.13 REF DIM ADDED ZONE B6 29.65 DIM WAS 29.71. ZONE D3 & D2 FLAG NOTE 9 ADDED.		AJS	08.02.27
A	NEW ISSUE		AJS	08.02.01
REV.	DESCRIPTION	BY	DATE	
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED	CE	DRAWING NO.	D3713	REV. B
MFG. APPR.	10	SHEET 1 OF 3		SCALE
APPROVED	10	TITLE		NTS
DE APPR.	10	LID ASSEMBLY		
DATE	08.02.27	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

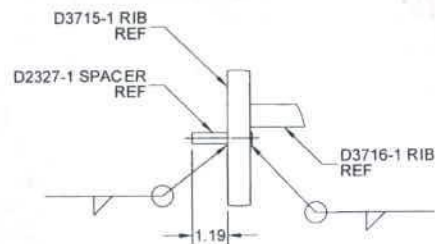


D3713-042 LID ASSEMBLY (SHOWN)
D3713-041 LID ASSEMBLY (OPPOSITE)
 (MESH SHOWN LOCALLY FOR CLARITY)

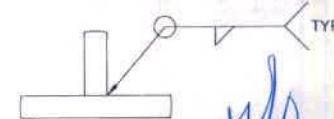
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ME	DRAWING NO.	REV. B
MFG. APPR.	ME	D3713	SHEET 2 OF 3
APPROVED	ME	TITLE	SCALE
DE APPR.	ME	LID ASSEMBLY	NTS
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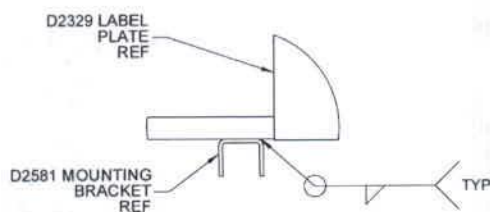
DETAIL A: TYP CORNER WELDS
SCALE 4X
(MESH NOT SHOWN FOR CLARITY)



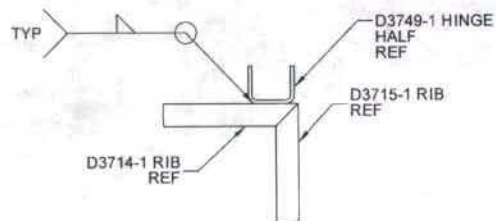
DETAIL B
TYP BOTH ENDS
SCALE 4X



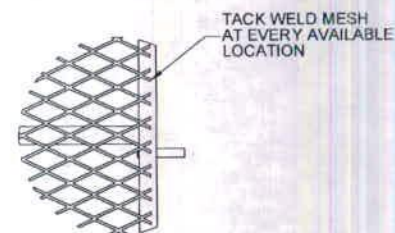
DETAIL C
TYP
SCALE 4X



DETAIL D
SCALE 4X

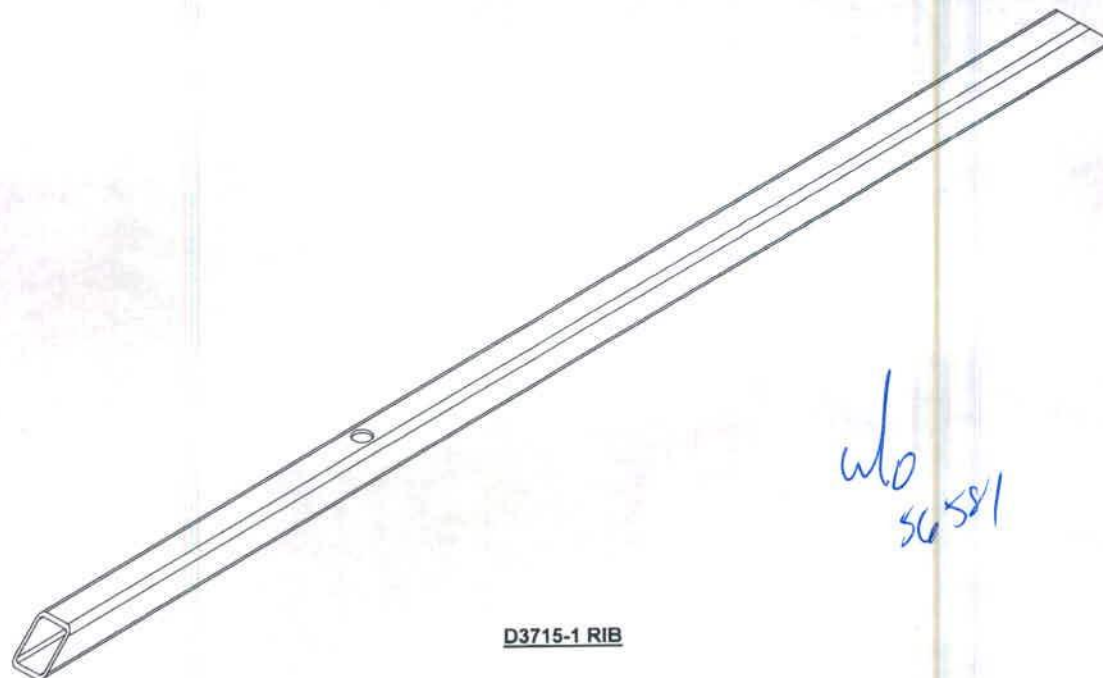


DETAIL E
SCALE 4X



DETAIL F
SCALE 5X

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ME	DRAWING NO.	REV. B
MFG. APPR.	ME	D3713	SHEET 3 OF 3
APPROVED	ME	TITLE	SCALE
DE APPR.	ME	LID ASSEMBLY	NTS
DATE	08.02.27	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D3715-1 RIB

w/o
56581

RELEASED
16 08.12.25

- NOTES:**
 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
 (REF. DART SPEC. M304TS0.750W0.065)
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 1.18 lbs

A	NEW ISSUE	AJS	08.02.01
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	LE	DRAWING NO.	REV. A
MFG. APPR.	ADP	D3715	SHEET 1 OF 2
APPROVED	ADP	TITLE	SCALE
DE APPR.	ADP	RIB	NTS
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